

Work Order ID 54645

December 15, 2009 12:04:31 PM



Page 1

Item ID: D3508-13

Accept



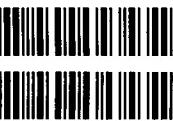
Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/15/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-12-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3508	Rev C
-------	-------

100



FLOW WATER JET

Waterjet

Memo

0.00

MF NOT pulled

B. 10-1-11

FLOW CNC Waterjet

304 .440

I-Cut as per Dwg D3508 Dwg Rev: C Prog Rev: L 2-

Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

B. 10-1-11

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

=> 10/01/11

1/6

f

PROD

W/O: 54645

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/11	#120	Took Qty +1 part for QC inspection Template	S	10/1/11	1	✓	✓ S 10/4/11

Part No: D3508-13 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54645

December 15, 2009 12:04:31 PM



Page 2

Item ID: D3508-13

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/15/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Brake NC

Memo

0.00

1-Form on brake using DT8326 and DT8261as per Dwg D3508

80 10/01/19 *16* *8*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

28 10/01/15

Memo

0.00

(X) 16 *8*

150



Large Fab

Large Fab

0.00

EZ 10-1-20 *4/15*

Large Fab

Memo

0.00

Weld hardcoat as per dwg D3508 QSI004 Hardcoat 2059b Batch: *M113521*

Pzr →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3508-13 PAR #: N/A Fault Category: Large Fob. NCR: Yes No DQA: *AS* Date: 10-01-21
 Resolution: Acceptable Disposition: Use-as-is QA: N/C Closed: *AS* Date: 10/01/26

WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date		
10/1/20	#150	welder welded the two strings of "hard coat" wrong. He welds the 1.63" gap at at the wrong end R.C. L.O.A. He wasn't paying	<i>AS</i> <i>AS/12</i>	-Part is acceptable. no structural it's only a wear place	<i>EL</i> 10-1-20	S (10-1-20)	<i>AS/12</i> S 10-1-20
		full attention to the Layout only the Dims on the Draw.					<i>S</i> 10-1-20

NOTE: Date & initial all entries

Work Order ID 54645

December 15, 2009 12:04:31 PM



Page 3

Item ID: D3508-13

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/15/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ S.10.12.0

(x16)

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

⇒ S.10.12.0

(x16) F

180



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

⇒ M.10.10.12.1

(x16) Ø

Powder Coating

START TIME: 6:45AM OVEN TEMPERATURE:
FINISH TIME: 7:15AM 370°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54645

December 15, 2009 12:04:31 PM



Page 4

Item ID: D3508-13

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/15/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

BK 10-01-21

(16)

∅



QC

Quality Control

Memo

200

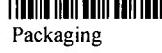
Identify as per dwg & Stock Location: FP-17

0.00

=> ML 10-01-21

(X16)

∅



Packaging

Packaging

Memo

0.00

210

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/01/21 JJ

MF 10-1-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 15, 2009 12:04:31 PM

Page 1

Work Order ID: 54645



Parent Item: D3508-13



Parent Item Name: Wearplate

Start Date: 12/15/2009

Required Date: 12/22/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No		100	sf		306.3536	2.1726	3.1 		

304/316 .040 Sheet

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	306.3536158	
110076	1.37053684	
112567	38.0765789	
112885	83.1578	112885
113062	166.3723	
113077	17.3764	

(17)

B 10-1-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	54645
Description: Wearplate	Part Number:	D3508-13
Inspection Dwg: D3508	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-11	Date:	10/1/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.23	New Issue	KJ/EC/DD	

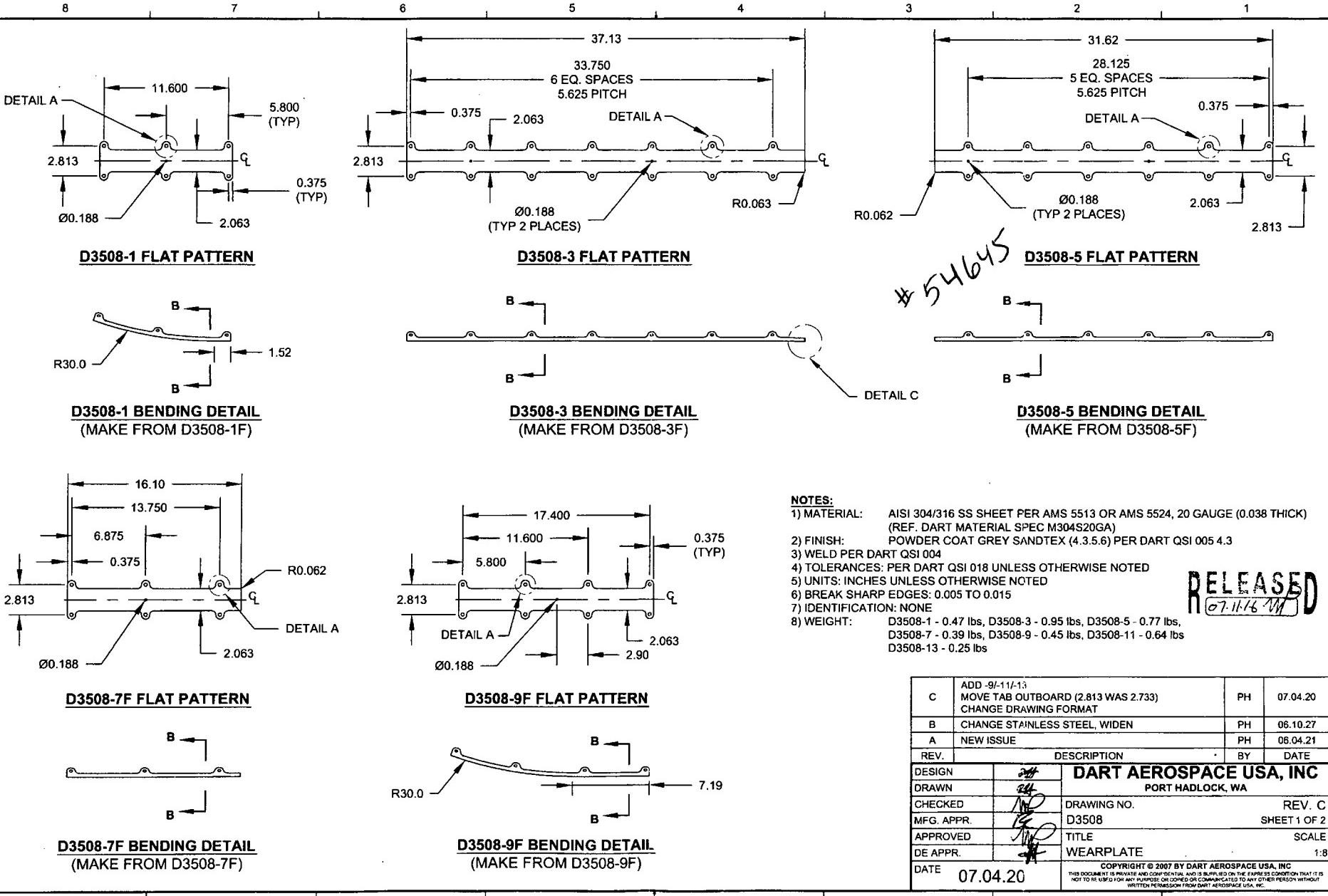
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



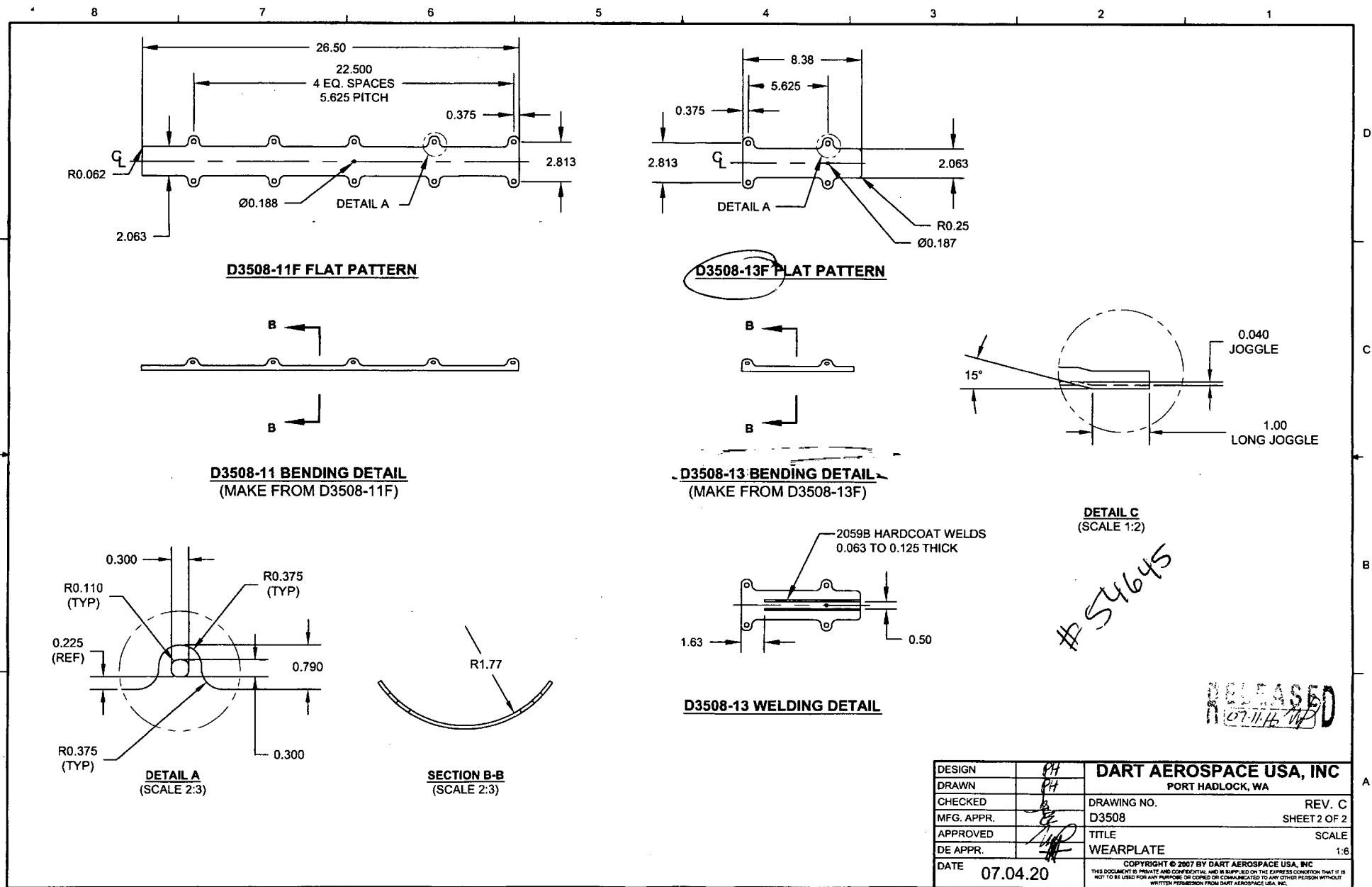
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries